

What is claimed is:

1. A method of manufacturing a wheel bearing device,
the device comprising: an outer member having outer
5 raceways in double rows at its inside periphery; an inner
member having inner raceways in double rows facing to the
outer raceways, an inside-diameter side member, and an
outside-diameter side member fitted onto the inside-
diameter side member with an irregular portion interposed
10 in between; rolling members in double rows disposed between
the outer raceways and the inner raceways,

wherein when the inside-diameter side member and the
outside-diameter side member are joined together by swaging
through expansion of at least a part of the inside-diameter
15 side member by a swaging jig pushed into an inside of the
inside-diameter side member to make the irregular portion
bite into an opposing face, the inside-diameter side member
is expanded in diameter while being pressed by the swaging
jig toward axially one side with the inside-diameter side
20 member being made butt against axially the other side of
the outside-diameter side member and the outside-diameter
side member at the axially one side being supported by a
receive member.

2. The method for manufacturing a wheel bearing device according to claim 1, wherein an outside diameter ϕA of the swaging jig, an inside diameter ϕB of a portion to be swaged out of portions of the inside-diameter side member, an inside diameter ϕC of the inside-diameter side member excluding the portion are set to the relationship of $\phi C > \phi A > \phi B$.

3. The method of manufacturing a wheel bearing device according to claim 1, wherein the swaging jig having a diameter reduced to a dimension smaller than an inside diameter of the portion to be swaged is inserted into an inside of the inside-diameter side member, and, at a position where the swaging jig has passed the portion to be swaged, the swaging jig is expanded in diameter to a dimension that is larger than the inside diameter of the portion to be swaged, and then is drawn out in a direction opposite to the insertion of the jig.

4. The method of manufacturing a wheel bearing device according to claim 3, wherein the swaging jig is such that a divided punch divided in a circumferential direction and an insertion member slideably inserted into the inside of the divided punch are taper-fitted together.

5. The method of manufacturing a wheel bearing device according to claim 1, wherein the inside-diameter side member is joined by swaging to the outside-diameter side member provided with the inner raceways.

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6. The method of manufacturing a wheel bearing device according to claim 2, wherein the inside-diameter side member is joined by swaging to the outside-diameter side member provided with the inner raceways.

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7. The method of manufacturing a wheel bearing device according to claim 3, wherein the inside-diameter side member is joined by swaging to the outside-diameter side member provided with the inner raceways.

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8. The method of manufacturing a wheel bearing device according to claim 4, wherein the inside-diameter side member is joined by swaging to the outside-diameter side member provided with the inner raceways.

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9. The method of manufacturing a wheel bearing device according to claim 1, wherein the inside-diameter side member is joined by swaging to the outside-diameter side member that is not provided with inner raceways.

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10. The method of manufacturing a wheel bearing device according to claim 2, wherein the inside-diameter side member is joined by swaging to the outside-diameter side member that is not provided with inner raceways.

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11. The method of manufacturing a wheel bearing device according to claim 3, wherein the inside-diameter side member is joined by swaging to the outside-diameter side member that is not provided with inner raceways.

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12. The method of manufacturing a wheel bearing device according to claim 4, wherein the inside-diameter side member is joined by swaging to the outside-diameter side member that is not provided with inner raceways.

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